

# Work Order ID 81863

*shd* *fabry* *f22*  
\*81863\*

Page 1

March-20-12 9:49:16 AM

Item ID: D350-567-141

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Floor Window Closeout Installation

Start Date: 3/20/12

Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 3/20/12

Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

DSI 9590

B

100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D350-567-141 CHG002

*LB*  
*Sizkulin*

110

Pick Kit

0.00

\*110\*

Packaging

Memo

0.00

Packaging

4

*12/04/10 LB*

120

QC4- 100% Inspect kits for completeness

0.00

\*120\*

QC

Memo

0.00

Quality Control

*Sizkulin*

*(74)*

**Work Order ID 81863****\*81863\***

Page 2

March-20-12 9:49:16 AM

Item ID: D350-567-141

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Floor Window Closeout Installation

Start Date: 3/20/12 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 3/20/12 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

**\*130\***

Packaging

Packaging

Memo

0.00

0.00

Identify and pack for shipping as per PPP D350-567-141  
Location: SHIP

140

**\*140\***

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

MLJ 12/04/12

ME  
12-04-12

# Picklist Print

March-20-12 9:49:14 AM

Page 1

Work Order ID: 81863

Parent Item: D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 3/20/12

Required Date: 3/20/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.11.09 new issue DD verf:JLM IPP REV:B 12.01.23 AS PER  
ECN12-511 DD VERF:EC IPP REV:C 12.03.05 AS PER ECN12-537 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3802-1 Window Seal		Manufactured	No			110	f	84.7500	2				
(D3802-1-024) CUT (1) AT 24" AS PER DWG, PER KIT													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST412		84.75							
				56881		0.75							
				81021		84							
D4434-041 Fwd Bracket Assembly		Manufactured	No			110	Each	0.0000	1				
D4434-047 Cover Assembly		Manufactured	No			110	Each	10.0000	1				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST		10							
				80658		10							
D4435-045 T/R Bellcrank Cover Assembly		Manufactured	No			110	Each	0.0000	1				
D4435-9 Bracket		Manufactured	No			110	Each	0.0000	1				
D4436-041 Aft Bracket Assembly		Manufactured	No			110	Each	0.0000	1				
D4441-1 Rubber Seal		Manufactured	No			110	f	275.1390	2				
(D4441-1-240) CUT (1) AT 24.00" PER KIT													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				prelim		6.739							
				74760		6.739							
				ST413		268.4							
				79385		250							
				80763		18.4							

measured  
8/26/10

81021  
80658  
8229114  
3x80650 +4  
1x80651 +8  
1x80659 +4  
80640 +4  
84x  
12/04/10

# Picklist Print

March-20-12 9:49:15 AM

Page 2

Work Order ID: 81863

Parent Item: D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 3/20/12

Required Date: 3/20/12

Start Qty: 1.00

Required Qty: 1.00

AN3-3A Bolt Purchased No

110 Each 713.0000 7

7 28 ✓ JB

h

Location

Loc Qty

Loc Code

ST350

713

120423

713

120423

AN525-832R7 Screw Purchased No

110 Each 680.0000 2

2 8 ✓ JB

h

Location

Loc Qty

Loc Code

ST345

680

120519

180

120560

500

120560

MS21042L06 Nut Purchased No

110 Each 428.0000 7

7 28 ✓ JB

e

Location

Loc Qty

Loc Code

ST300

428

118354

2

119109

1

119758

1

120360

424

120360

MS21042L08 Nut Purchased No

110 Each 495.0000 2

2 8 ✓ JB

12/04/10

Location

Loc Qty

Loc Code

ST300

495

120142

95

120648

200

120833

200

March-20-12 9:49:15 AM

Shop Packet Print

Page 2

# Picklist Print

March-20-12 9:49:15 AM

Work Order ID: 81863

Parent Item: D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 3/20/12

Required Date: 3/20/12

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

3,027.0000

5

5 20

JB

*[Handwritten signature]*

Nut

## Location

## Loc Qty

## Loc Code

ST300

3027

117441

16

117885

32

118451

5

118927

3

119017

2798

119075

173

119017

MS21059L3,

Purchased

No

110

Each

257.0000

2

28

JB

*[Handwritten signature]*

Nut, Plate

## Location

## Loc Qty

## Loc Code

ST301

28

118614

8

119546

20

ST302

229

120308

29

120833

100

121011

100

120833

MS35206-229

Purchased

No

110

Each

380.0000

7

28

JB

12/04/10

Screw

## Location

## Loc Qty

## Loc Code

ST293

380

121039

380

121039

*[Handwritten signature]*

# Picklist Print

March-20-12 9:49:15 AM

Page 4

Work Order ID: 81863

Parent Item: D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 3/20/12

Required Date: 3/20/12

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P  
WASHER

Purchased No

110 Each 642.0000

12

121166 12 48

JB

✓

## Location

## Loc Qty

## Loc Code

ST275

642

117735

37

119225

14

120498

188

120910

200

120986

200

17317

3

NAS1149FN616P  
WASHER

Purchased No

110 Each 1,101.0000

14

1456

JB

✓

## Location

## Loc Qty

## Loc Code

ST275

1101

117317

101

120560

1000

NAS1149FN882P  
Washer

Purchased No

110 Each 0.0000

2

120560

121039

28

JB

12/04/10

## 2.0 Part List

Qty -141	Part Number	Description
<b>X</b>	<b>D350-567-141</b>	<b>FLOOR WINDOW CLOSE-OUT KIT</b>
1	D3802-1-024	SEAL (24")
1	D4434-041	FWD BRACKET ASSEMBLY
1	D4434-047	COVER ASSEMBLY
1	D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	D4435-9	BRACKET
1	D4436-041	AFT BRACKET ASSEMBLY
1	D4441-1-240	RUBBER SEAL (24")
7	AN3-3A	BOLT
2	AN525-832R7	SCREW
7	MS21042L06	NUT (OR MS21042-06)
2	MS21042L08	NUT (OR MS21042-08)
5	MS21042L3	NUT (OR MS21042-3)
2	MS21059L3	NUTPLATE
7	MS35206-229	SCREW
12	NAS1149F0332P	WASHER (AN960-10L)
14	NAS1149FN616P	WASHER (OR AN960-6L)
2	NAS1149FN816P	WASHER (OR AN960-8L)



## 3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141 Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
<b>D350-567-141</b>	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kG	1.66 m	2.94 m-kG

## 4.0 Installation Procedure

Notes:




- Figure 2 shows the general arrangement and installation of the D350-567-141 Close-out Kit. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
  - D350-567-115 — OK to remove D3295-041
  - D350-567-031 — OK to remove D3212-1
  - D350-567-011 — OK to remove D2214
  - D350-567-021 — OK to remove D2951
- It is acceptable to drill/trim the D350-567-141 Close-out Kit as required to improve fit.

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

**APPROVED**

BY:   
D. SHEPHERD (DE # 02)

DATE: 12.03.13  
CERT. NO.: SH92-18  
ISSUE NO.: 6

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. <b>DSI 9590</b>
MFG. APPR.	N/A	REV. C SHEET 2 OF 12
APPROVED		TITLE <b>FLOOR WINDOW CLOSE-OUT KIT</b>
DE APPR.		SCALE NTS
DATE <b>12.03.13</b>		COPYRIGHT © 2012 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>

# REFERENCE ONLY

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CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: MSH  
D. SHEPHERD (DE # 02)

DATE: 12.03.13  
CERT. NO.: SH92-18  
ISSUE NO.: 6

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<u>RF</u>	DRAWING NO.	REV. C
MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 12
APPROVED	<u>RF</u>	TITLE	SCALE
DE APPR.	<u>RF</u>	FLOOR WINDOW CLOSE-OUT KIT	NTS
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